

Date: Monday, 22/09/2008 1:05:30 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 42182		
Estimate Number	: 12322		
P.O. Number	:	Part Number	: D3492041
This Issue	: 22/09/2008 S.O. No. :	Drawing Number	: D3492 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 41137	Material	:
Written By	:	Due Date	: 29/09/2008 Qty: 100 Um: Each
Checked & Approved By	: <u>JUL 08.9.22</u>		
Comment	: est rev A 06.03.03 New Issue EC Est Rev:B 06-08-28 As per Rev B JLM Est Rev:C 07-12-06 Rev C dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0625	6061-T6 Round Bar .625"
Comment: Qty.: 0.0656 f(s)/Unit Total : 6.5625 f(s) 6061-T6 Round Bar .625" (M6061T6R0625) m108548 Batch: m108548 mmt 08/09/29		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Folio FA633 & Dwg D3492 Dwg Rev: <u>C</u> Folio Rev: <u>B</u> mmt 08/09/29		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE mmt 08/09/29		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK R.A 08/10/02		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr if neccessary E/B 08/10/15		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/09/2008 1:05:30 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 42182

Part Number: D3492041

Job Number:



Seq. #:

Machine Or Operation:

Description:

2-Tumble

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-10-15

x100

7.0

POWDER COATING

POWDER COATING



M109152



100X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(Flat End Only)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3=45
320°F
4-15

M-1 08/10/15

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



100

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F2 08/10/16

9.0

NAS1611010

O-RING



100X

Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-010 O-RING
(or MS28775-010)

M101029 M-1 08/10/16

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



100X

Comment: Hand Finishing

1- Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube

A/R 55-O'Ring Lube Batch:

M101223 M-1 08/10/16

11.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

5 08/10/16 x100

12.0

PACKAGING 1

PACKAGING RESOURCE #1



100X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

F P-B

M-1 08/10/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/09/2008 1:05:30 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 42182

Part Number: D3492041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/16 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



ME 08-10-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42182
Description: Plug		Part Number: D3492-1
Inspection Dwg: D3492	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

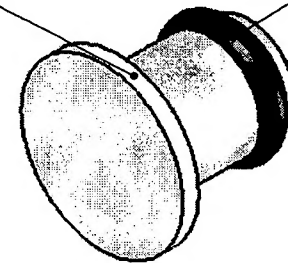
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.005	.060	✓			
0.060	+/-0.005	.060	✓			
Ø0.394	+/-0.010	Ø.394	✓			
Ø0.625	+/-0.010	Ø.625	✓			
0.090	+0.000/-0.002	.089	✓			
0.500	+/-0.010	.499	✓			
0.055	+0.000/-0.002	.055	✓			
0.050 x 20°	+/-0.010	.050 x 20°	✓			

Measured by: mnf	Audited by: J.L	Prototype Approval:	N/A
Date: 08/09/09	Date: 08/10/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.02	New Issue P/O D3492-041	KJ/JLM	
B	06.10.16	Ø0.625 was Ø0.500	KJ/JLM	
C	07.11.23	Tolerances revised	KJ/EC/DD	
D	08.06.19	0.050 x 20° dimension added	KJ/DD	

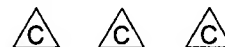
D3492-XX PLUG
(SEE TABLE)

NAS1611 PLUG
(SEE TABLE)



D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING



NOTES:

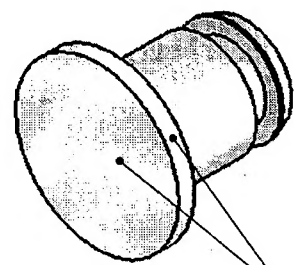
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42180

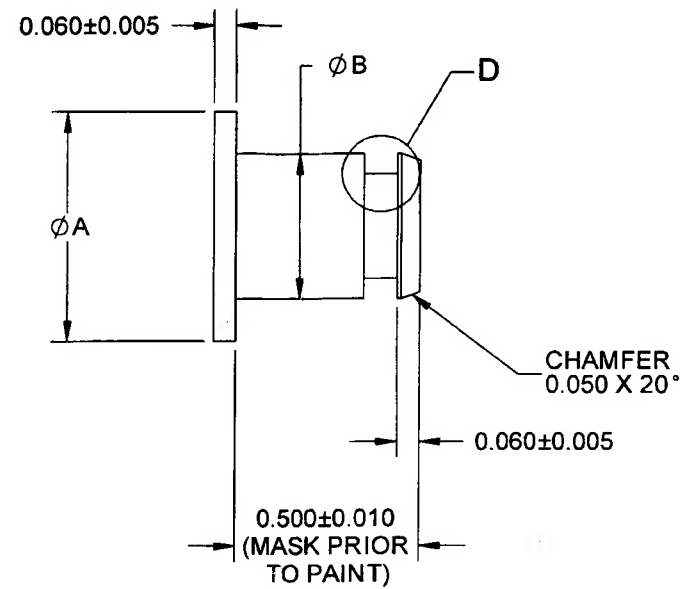
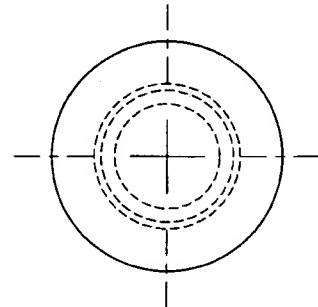
01.07.21.08
UNDER REVIEW
DIM 08 ON D3492-13
REV. 0X (MAKE SMALLER)

RELEASED
07.10.05

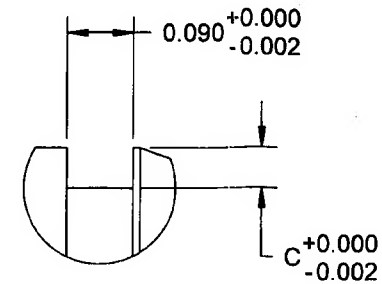
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3492	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLUG	2:1
DATE	07.10.05	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



POWDER COAT THESE
FACES ONLY PER NOTE 2



D3492-XX PLUG



DETAIL D

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.520	0.045	M6061T6R0.750

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

06.19.22
UNDER REVIEW
07.04.21 RB
DIM ØB ON D3492-13
REST OK (MAKE SMALLER)
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42182
RELEASED
07.11.16

DESIGN	PL	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	PL	
CHECKED	PL	DRAWING NO. REV. C
MFG. APPR.	PL	D3492 SHEET 2 OF 2
APPROVED	PL	TITLE SCALE
DE APPR.	PL	PLUG 4:1
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